

Date: Wednesday, 1/30/2008 7:53:07 AM  
 User: Kim Johnston

## Process Sheet

SPLIT-2

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 37059 -2  
 Estimate Number : 11341  
 P.O. Number :  
 This Issue : 1/30/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 11 Type : LARGE FAB ASSY  
 Previous Run : 35442  
 Written By :  
 Checked & Approved By : JF 08 01 30  
 Comment : Est: A 05.01.13 New issue KJ/JLM

Drawing Name : PIN ASSEMBLY  
 Part Number : D3332043  
 Drawing Number : D3332 REV. A1  
 Project Number : N/A  
 Drawing Revision : A1  
 Material :  
 Due Date : 2/5/2008 Qty: 10 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1018R0500 1018-1025 Steel Bar



Comment: Qty.: 0.1749 f(s)/Unit Total: 1.7493 f(s)

1018-1025 Steel Bar

Material: AISI 1018-1025 Ø0.500" Round Bar

(M1018-R0.500)

Identify for D3332-37

Batch: M16634

M106996

J.F. 08/05/23 J.F.

08/02/01

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Machine D3332-7 as per Folio FA493 and Dwg D3332

J.F. 08/05/23 J.F. 08/02/01

(5)

(33)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/05/23 J.F. 08/02/01

(PW)

(33)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 08/05/23

J.F. 08/02/01

(5)

5.0 M1018R0313 1018-1025 Steel Bar



Comment: Qty.: 0.2836 f(s)/Unit Total: 2.8361 f(s)

1018-1025 Steel Bar

Material: AISI 1018-1025 Ø0.313" Round Bar

(M1018-R0.313)

Identify as D3332-9

Batch: 417270

M17270 → 10x

J.F. 08/05/26

Date: Wednesday, 1/30/2008 7:53:07 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIN ASSEMBLY

Job Number: 37059

Part Number: D3332043

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
Fabricate D3332-9 as per Dwg D3332

*JS 08/05/26*

7.0

D33321

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)  
Handle Assembly

Pick:

Qty Part Number Description Batch

1 D3332-1 Handle

A/R N/A Steel Rod

Identify as D3332-043

*B37083 → 10x*  
*M105138*

*JS 08/05/26*

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
Assemble and Weld using D3332-041T1 as per Dwg D3332

*JS 08/05/26*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*JS 08/05/27 (+16)*

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*30 min*  
*27/05/2008*  
*8.283*  
*17.07*  
*#1 318.5*  
*#2 B337059*  
*#3 D3332043*  
*#4*

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3  
Cover thread only for D3332-9 prior to painting

*M18052*

*M/A 08/05/27*

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*FL 08/05/27*

*(10)*



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIN ASSEMBLY

Job Number: 37059

Part Number: D3332043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



(10x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 490

8/5/27

SD

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/29

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

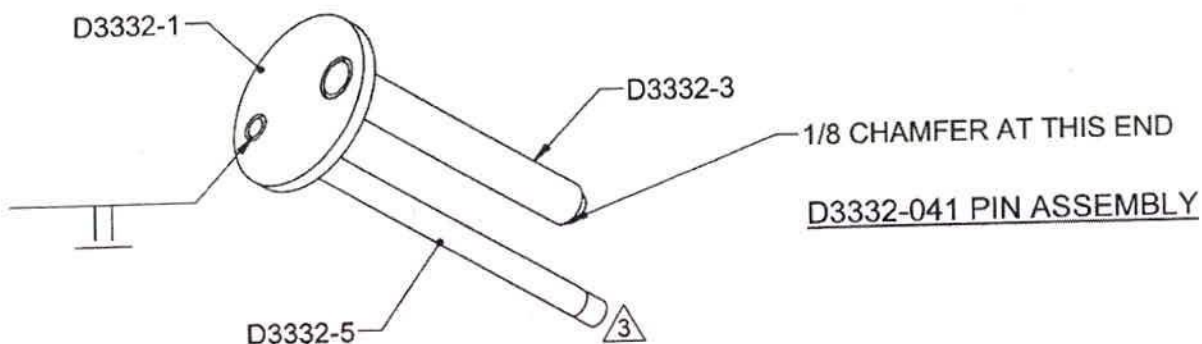


MF 08-05-29



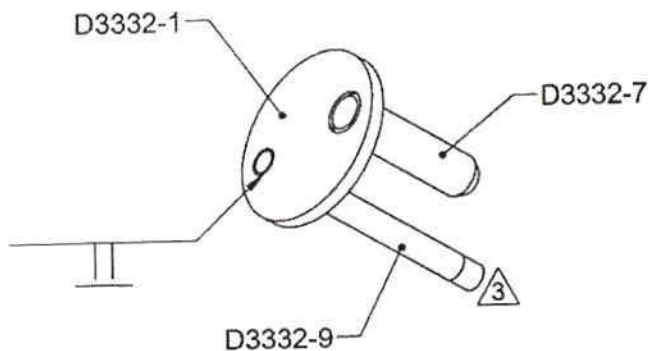


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3332	REV. A SHEET 1 OF 4
DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:2
A	04.12.14	NEW ISSUE	
A1	<i>[Signature]</i> 05.07.04	0.080 WAS 0.050; ADD TOLERANCE TO 0.000 -0.005	



D3332-041 PIN ASSEMBLY

RELEASED  
*[Signature]*  
05/02/09



D3332-043 PIN ASSEMBLY

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WORK ORDER  
NO. 37059

**NOTES:**

- 1) POSITION PARTS USING D3332-041T1
- 2) WELD PER DART QSI 004
- 3) MASK THREADS PRIOR PAINTING
- 4) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3  
(COVER THREAD ONLY FOR D3332-5/-9 PRIOR PAINTING)
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.10

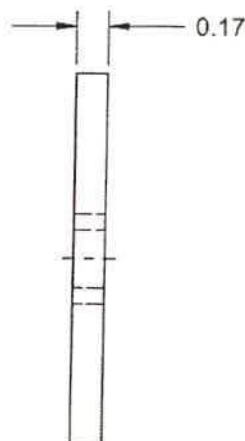
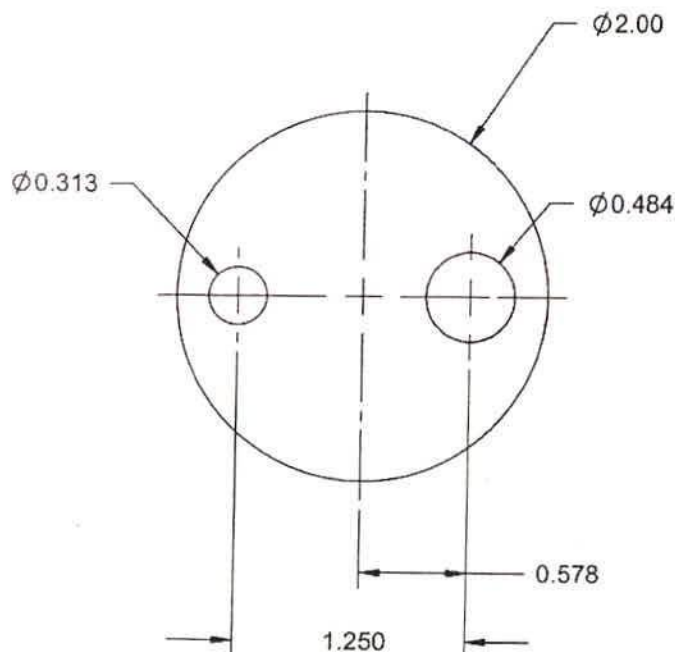
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DATE <b>04.12.14</b>		TITLE <b>PIN ASSEMBLY</b>	SCALE 1:1



RELEASED  
*[Signature]*  
5/04/09

**D3332-1 HANDLE****NOTES:**

- 1) MATERIAL: 1018-25 ROUND BAR STEEL PER MIL-S-7097  
(REF. DART SPEC. M1018-R2.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

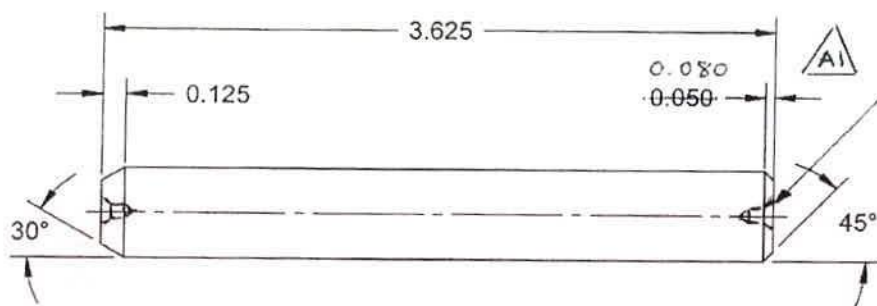
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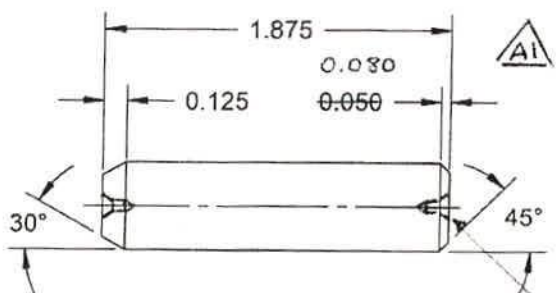
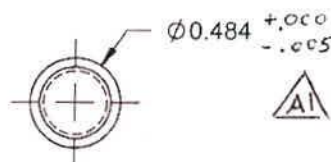


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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



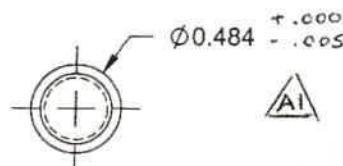
3332-3 PIN

USE CENTER DRILL  
AS REQUIRED (TYP)



3332-7 PIN

USE CENTER DRILL  
AS REQUIRED (TYP)



**NOTES:**

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097  
(REF. DART SPEC. M1018R0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED  
*[Signature]*  
05/02/09

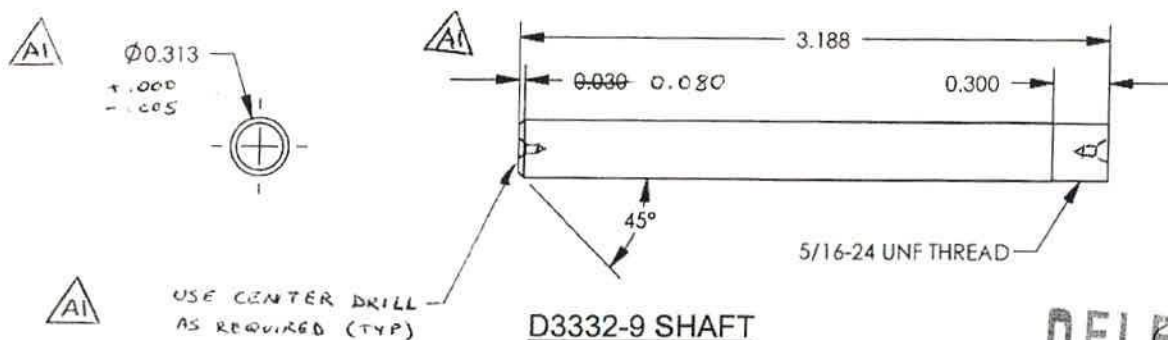
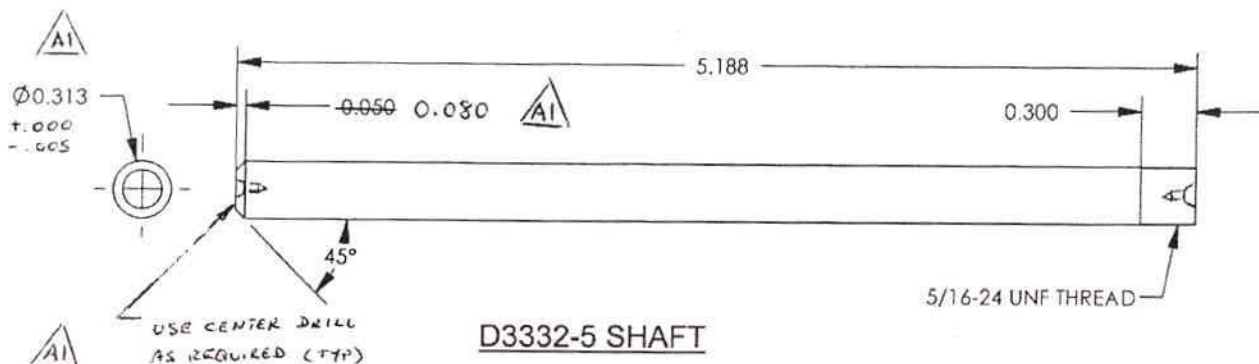
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DATE 04.12.14		TITLE PIN ASSEMBLY	SHEET 4 OF 4 SCALE 1:1

**NOTES:**

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097 (REF. DART SPEC. M1018-R0.313)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES

**RELEASED**

0 9/22/09  
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